

What is claimed is:

1. A resin piston for a master cylinder comprising: a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material; and
5 a burr generated by a flow of said resin material into a gap between a combined molding die and a core in a process of molding of said resin piston by injection molding, said burr projecting out from said communicating hole into the through-hole.
- 10 2. The resin piston for a master cylinder of claim 1, wherein a groove is provided in a portion of an inner wall surface of said through-hole, the groove facing said communicating hole, the groove being in the shape of a flat surface oriented in a direction substantially perpendicular to the longitudinal direction in which said stopper pin travels in operation of said master cylinder.
- 15 3. The resin piston for a master cylinder as in claim 2, wherein a width of said groove is narrower than that of said through-hole and wider than a diameter of said stopper pin.
4. The resin piston for a master cylinder of claim 1, wherein said through-hole includes a projecting part for preventing said stopper pin from being touched to said resin piston near said communicating hole.
- 20 5. The resin piston for a master cylinder of claim 1,
wherein said through-hole is molded with a core for through-hole molding;
said concavity and said communicating hole are molded with a core for molding a concavity; and
a portion of said resin piston where said through-hole communicates with said
- 25 communicating hole is molded in a manner such that an end of said core for molding said concavity is impacted in an impact hole formed in said core for through-hole molding to produce a burr projecting out from the communicating hole into the through-hole.
6. The resin piston for a master cylinder as in claim 5, wherein:

said resin piston for a master cylinder is molded with a die formed by a combination of a first die and a second die, the first die including a first core, the second die including a second core; and

5 said core for through-hole molding is constructed by a combination of the first core and the second core, whereby said impact hole is formed.

10. The resin piston for a master cylinder of claim 5,

wherein said through-hole is molded with a core for through-hole molding; said concavity and said communicating hole are molded with a core for molding a concavity; and a groove is provided in a portion of an inner wall surface of said through-hole, the groove facing 10 said communicating hole, the groove being in the shape of a flat surface oriented in a direction substantially perpendicular to the longitudinal direction in which said stopper pin travels in operation of said master cylinder.

11. A master cylinder equipped with a resin piston for said master cylinder, said resin piston for a master cylinder comprising:

15 a through-hole through which a stopper pin being a component of a valve mechanism of said master cylinder is inserted, a concavity in which said valve mechanism is fixed by being inserted therein, and a communicating hole communicating with said through-hole from said concavity, said resin piston for a master cylinder being molded by injection of a resin material,

20 a burr generated by a flow of said resin material into a gap between a combined molding die and a core in a process of molding of said resin piston for a master cylinder by injection molding, said burr projecting out from said communicating hole into the through-hole.

12. The master cylinder of claim 11,

wherein said through-hole is molded with a core for through-hole molding; said concavity and said communicating hole are molded with a core for molding a concavity; and a 25 portion of said resin piston where said through-hole communicates with said communicating hole is molded in a manner such that an end of said core for molding said concavity is impacted in an impact hole formed in said core for through-hole molding to produce a burr projecting out from the communicating hole into the through-hole.

13. The master cylinder of claim 11,
wherein said through-hole is molded with a core for through-hole molding; said
concavity and said communicating hole are molded with a core for molding a concavity; and
a groove is provided in a portion of an inner wall surface of said through-hole, the
5 groove facing said communicating hole, the groove being in the shape of a flat surface oriented
in a direction substantially perpendicular to the longitudinal direction in which said stopper pin
travels in operation of said master cylinder.

14. A die for molding a resin piston for a master cylinder, said resin piston for a
master cylinder comprising:

10 a through-hole through which a stopper pin being a component of a valve mechanism of
said master cylinder is inserted, a concavity in which said valve mechanism is fixed by being
inserted therein, and a communicating hole communicating with said through-hole from said
concavity, said resin piston for a master cylinder being molded by injection of a resin material,
said die comprising a core for molding said through-hole and a core for molding said concavity
15 and said communicating hole, wherein said die is so constructed such that a portion of said resin
piston where said through-hole communicates with said communicating hole is molded in a
manner such that an end of said core for molding said concavity is impacted in an impact hole
formed in said core for through-hole molding to produce a burr projecting out from the
communicating hole into the through-hole.

20 15. A method for manufacturing a resin piston for a master cylinder, comprising
the steps of:

providing a through-hole through which a stopper pin being a component of a valve
mechanism of a master cylinder is inserted;

25 providing a concavity in which said valve mechanism is fixed by being inserted therein,
providing a communicating hole communicating with said through-hole from said concavity,
said resin piston for a master cylinder being molded by injection of a resin material;
molding said through-hole with a core for through-hole molding;

molding said concavity and said communicating hole with a core for molding a concavity; and

- molding a portion of said resin piston where said through-hole communicates with said communicating hole in a manner such that an end of said core for molding said concavity is
5 impacted in an impact hole formed in said core for through-hole molding to produce a burr projecting out from the communicating hole into the through-hole.